

Work Order ID 59794



Page 1

Friday, June 11, 2010 12:50:57 PM

Item ID: D350-591-216

Accept



Setup

Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short RH

Start Date: 6/10/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: *RP*

Date: *10-6-11*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3168

Rev A

DSI 9472

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-216 CHG003

8/10/12/28

Pho →
10/07/27

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168
2-Drill extrusion as per Dwg D3168 using Jig DT8680 for rivets.(Use only 1st 6holes)
3-Deburr

10-06-21

1

W/O: 59794

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/7/16	#100	Per. <u>Large</u> check + Fix Routin number, to correct sequences	B	10.07.29			S 10/6/16

Part No: D350-591-216 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59794

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Item ID: D350-591-216

Revision ID:

Item Name: Heli-Access-Step, Short RH

Start Date: 6/10/2010 Start Qty: 1.00

Required Date: 6/25/2010 Req'd Qty: 1.00

Reference:

Accept

Setup

Start

Stop

Cust Item ID:

Customer:

Run

Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

130



Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8780, weld Fwd End Plate as per QSI 004 & Dwg D3168
A/R Aluminum Rod M11220
3-Grind End Plate flush M114242

0.00

0.00

M10-06-21

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

Memo

D 10.07.20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 6/10/2010 Start Qty: 1.00

Required Date: 6/25/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

5/10/07/20

QC

Memo

0.00

Quality Control

8/1/07/20

160

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

10-07-20

Hand Finishing

1/07/20

170

QC3- Inspect Part Finish

0.00

27/07/20

QC

Memo

0.00

Quality Control

1/07/20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-591-216

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Start Date: 6/10/2010 Start Qty: 1.00

Required Date: 6/25/2010 Req'd Qty: 1.00

Reference:

Accept



Setup

Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Large Fab

Large Fab

0.00

Memo

Rivet Leg Assembly as per Dwg D3168

0.00

10.07.22

1

Ø

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

10.07.22

0.00

200



Large Fab

Large Fab

0.00

Memo

1-Bevel Aft end for welding
2-Inspect for foreign object as per QSI 024
3-Weld Aft End Plate as per QSI 004 & Dwg D3168
A/R Aluminum Rod 1112360
4-Grind End Plate flush

0.00

10.07.22

1

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Start Date: 6/10/2010 Start Qty: 1.00

Required Date: 6/25/2010 Req'd Qty: 1.00

Reference:

Accept

Setup

Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

① PD 10.07.22

220

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S 10/07/12

②

RM

230

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

12th. 10-7-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Revision ID:

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Stop



Start Date: 6/10/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:00

OVEN TEMPERATURE:

320° FINISH TIME:

11:30

1 BK 10-7-23

250

Wing Walk
~~Pressure Wash~~ per QSI005 4.3

0.00



HandFinish

B# 114432

Memo

0.00

Hand Finishing

ml 10 07 26 (1)

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 color/2c

(4) PRV

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item Name: Heli-Access-Step, Short RH

Start Date: 6/10/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

16-7-28

S/10

280

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S 10/7/28

10

290

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-216

Location: 51PPP Rev: C

6/10/28 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D350-591-216

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Revision ID:

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Item Name: Heli-Access-Step, Short RH

Start Date: 6/10/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 1.00

Customer:

Reference:

Run

Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u 10-07-28

10/07/28 JG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, June 11, 2010 12:51:01 PM

Page 1

Work Order ID: 59794

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:A ☐ 02.10.17 ☐ New issue ☐ KJ
 IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
MS21042L4		Purchased	No			110	Each	3,772.000	6	6			

Nut

Location	Loc Qty	Loc Code
ST139	2	
111827	2	
ST300	3770	
113422	68	
114523	694	
114718	1000	
114784	2000	
9003	8	

D3067-1
 End Plate

Manufactured No

130 Each 23.0000

Location	Loc Qty	Loc Code
WA	23	
57926	23	

D3170-1
 Spacer

Manufactured No

130 Each 37.0000

Location	Loc Qty	Loc Code
Mezz	37	
35824	37	

10.7.27

10.06.21

10.07.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	1							

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 59794

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:A 02.10.17 New issue KJ
IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3077-1		Manufactured	No			180	Each	36.0000	2	2			
Step Leg													
<div> <div>Location</div> <div>WA</div> <div>26684</div> <div>35817</div> </div> <div> <div>Loc Qty</div> <div>36</div> <div>12</div> <div>24</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3169-1		Manufactured	No			180	Each	16.0000	1	1			
Support													
<div> <div>Location</div> <div>WA</div> <div>26685</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>16</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
MS20600-AD4W4		Purchased	No			180	Each	119.0000	12	12			
Rivets													
<div> <div>Location</div> <div>ST321</div> <div>114935</div> <div>113368</div> <div>114181</div> <div>114718</div> </div> <div> <div>Loc Qty</div> <div>119</div> <div>62</div> <div>11</div> <div>46</div> </div> <div> <div>Loc Code</div> <div></div> </div>													
D3067-1		Manufactured	No			200	Each	23.0000	1	1			
End Plate													
<div> <div>Location</div> <div>WA</div> <div>359596</div> <div>57926</div> </div> <div> <div>Loc Qty</div> <div>23</div> <div>23</div> </div> <div> <div>Loc Code</div> <div></div> </div>													

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 59794

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:A ☐ 02.10.17 ☐ New issue ☐ KJ
 IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
AN3-35A		Purchased	No			270	Each	57.0000	2	2			

Bolt

Location	Loc Qty	Loc Code
ST353	57	
114382	27	
114784	30	

M115016 10-7/27 sl

AN4-11A
Bolt

Purchased No 270 Each 333.0000

Location	Loc Qty	Loc Code
ST357	333	
110382	333	

6 10-7/27 sl

AN4-13A
Bolt

Purchased No 270 Each 207.0000

Location	Loc Qty	Loc Code
ST357	207	
114752	207	

4 M114941 10-7/27 sl

AN4-16A
Bolt

Purchased No 270 Each 109.0000

Location	Loc Qty	Loc Code
ST358	109	
114330	9	
114523	100	

4 10-7/27 sl

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-591-216

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Comments: IPP Rev:A ☐ 02.10.17 ☐ New issue ☐ KJ
 IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
AN960JD10	NAS1149D0363J	Purchased	No			270	Each	0.0000	4	4			
Washer													
AN960JD416	NAS1149D0463J	Purchased	No			270	Each	18.0000	12	12			
Washer													
<div> <div>Location</div> <div>ST357</div> <div>107939</div> </div> <div> <div>Loc Qty</div> <div>18</div> <div>18</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2230-1		Manufactured	No			270	Each	69.0000	2	2			
Lug													
<div> <div>Location</div> <div>ST476</div> <div>54755</div> <div>57828</div> </div> <div> <div>Loc Qty</div> <div>69</div> <div>1</div> <div>68</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2230-3		Manufactured	No			270	Each	77.0000	2	2			
Lug													
<div> <div>Location</div> <div>ST476</div> <div>57827</div> <div>59115</div> </div> <div> <div>Loc Qty</div> <div>77</div> <div>1</div> <div>76</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

M115107 10.7.27

M115000 10.7.27

B59909 10.7.27

B59418 10.7.27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Short RH

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 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D2622-120C		Manufactured	No			270	Each	151.9200	0.5	0.5			
Step Extrusion													

						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA	151.92						
						55214	12.92						
						58544	139						
D2732		Manufactured	No			270	f	385.8000	0.5	0.5			
Rubber Extrusion													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST412	385.8						
						56516	385.8						
D2856-400		Manufactured	No			270	f	245.5088	0.6	0.6			
Abrasion Strip													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST403	245.5088						
						50593	43.4568						
						56626	202.052						

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Page 5

W/O: 59794		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/7/26	100	perm change ADD qty and length to D2732-030 ADD qty and length to D2586-400-770	B	10.07.29			S 10/07/26	

Part No: D350-591-216 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 59794

Parent Item: D350-591-216

Parent Item Name: Heli-Access-Step, Short RH


Comments: IPP Rev:A ☐ 02.10.17 ☐ New issue ☐ KJ
 IPP Rev:B 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
MS21042L3		Purchased	No			270	Each	3,273.000	2	2			
													
Nut													

Location	Loc Qty	Loc Code
ST300	3273	
113537	18	
113644	3	
114523	752	
114718	500	
114784	2000	

10.7/27.5/ (Signature)

2

Friday, June 11, 2010 12:51:01 PM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>ap</i>	DRAWN BY <i>ap</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3168	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011

Part No.	Description	QTY -041	QTY -042
D3168-041	Step Assembly, Low Short (LH)	X	
D3168-042	Step Assembly, Low Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3067-1	END PLATE	2	2
D3077-1	STEP LEG	2	2
D3169-1	SUPPORT	1	1
D3170-1	SPACER	2	2
MS20600AD4W4	RIVET	12	12

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3169-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE
WORK ORDER
NO. 59794
3010-64

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

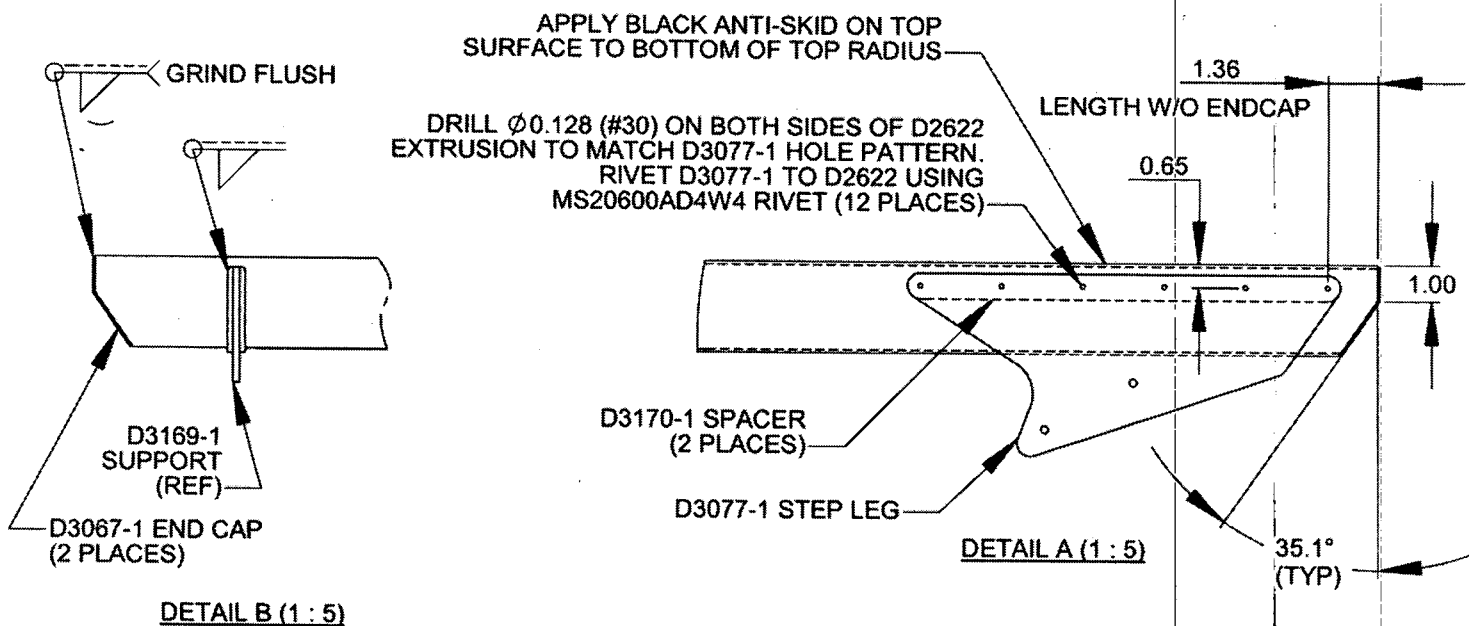
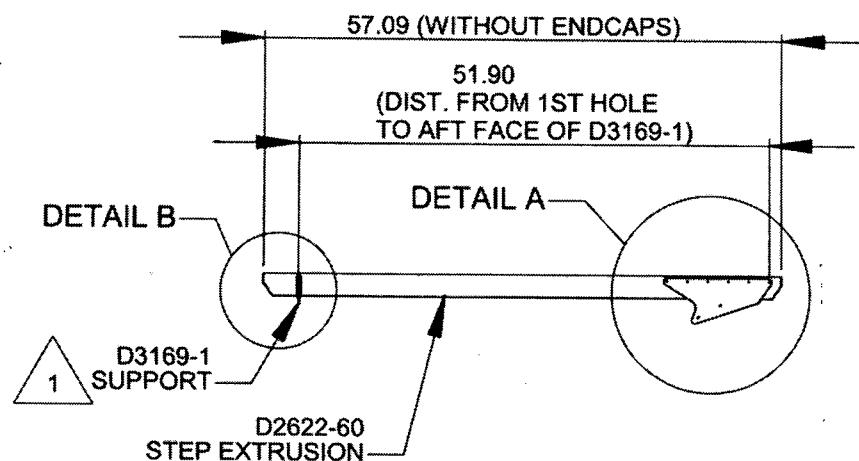
DART



52.69
- 1.36
55.93

DESIGN	AP	DRAWN BY	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	APPROVED	AP	REV. A
DATE	02.09.11	DRAWING NO.	D3168	SHEET 2 OF 2
TITLE	STEP ASSEMBLY, LOW SHORT	SCALE	1:20	

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02.09.2011



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6


REF FAA STC: SH967NE



For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-214	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-215	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-216	Heli-Access-Step ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	09.08.05
CERT. NO.:	SH92-6
ISSUE NO.:	11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. A
CHECKED	LP	DSI 9472	SHEET 1 OF 2
MFG. APPR.	NDA	TITLE	SCALE
APPROVED		BOLT ADDITION	NTS
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